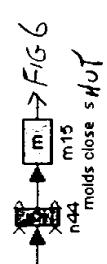
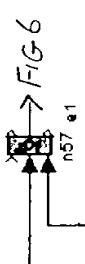


→ FIG 7

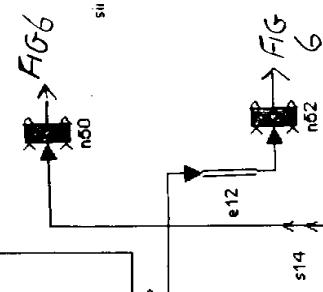
→ FIG 6



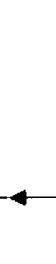
→ FIG 6



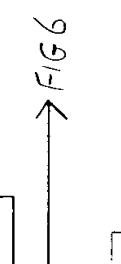
→ FIG 6



→ FIG 6



→ FIG 6



→ FIG 6

FIG 4 {

m35  
n128  
s54  
c54  
s45  
e55  
m35

→ FIG 6

FIG 4 {

m36  
n145  
s16  
c16  
s45  
e16  
m36

→ FIG 5

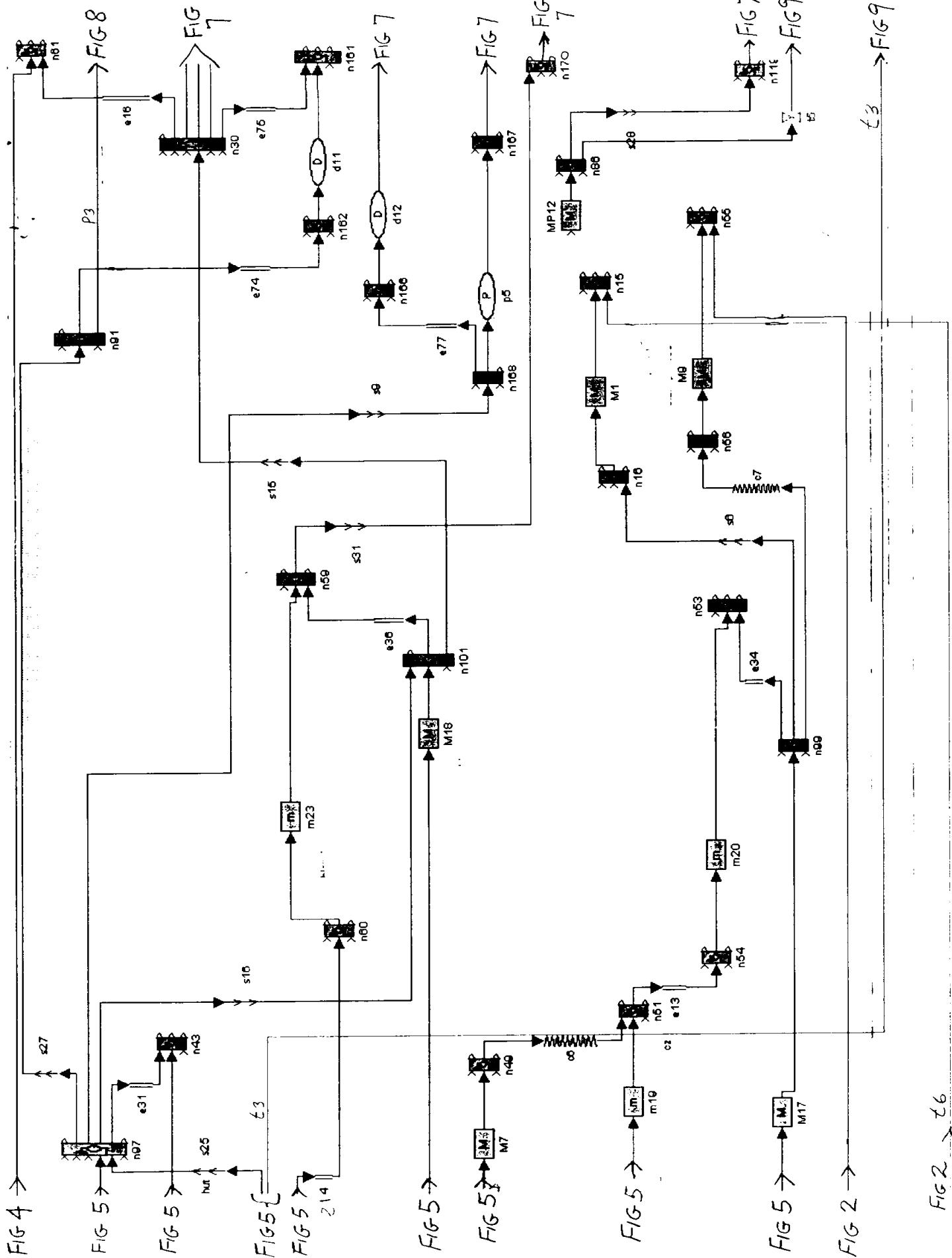


Fig 5 → t 4

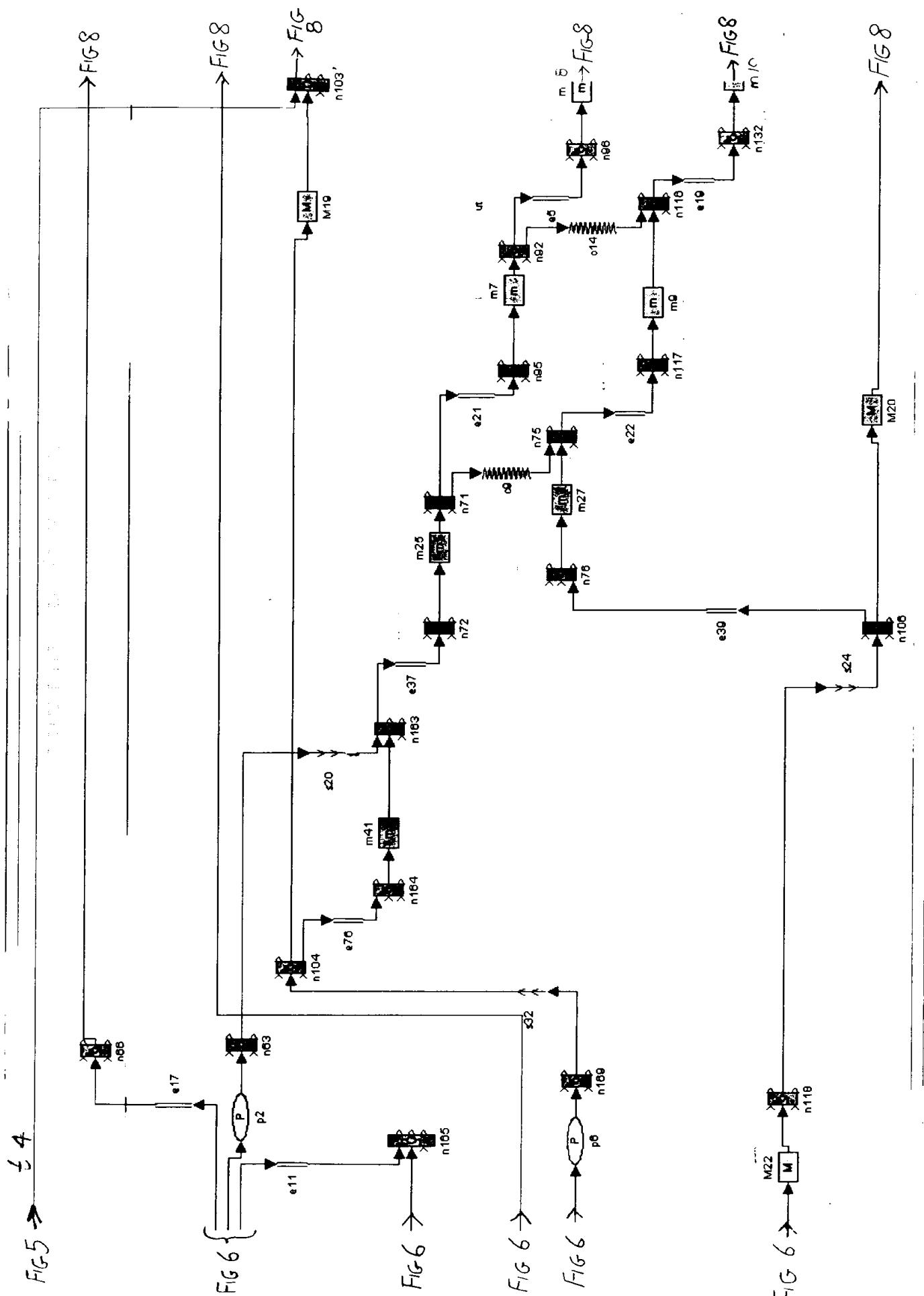


Fig 7

FIG 8

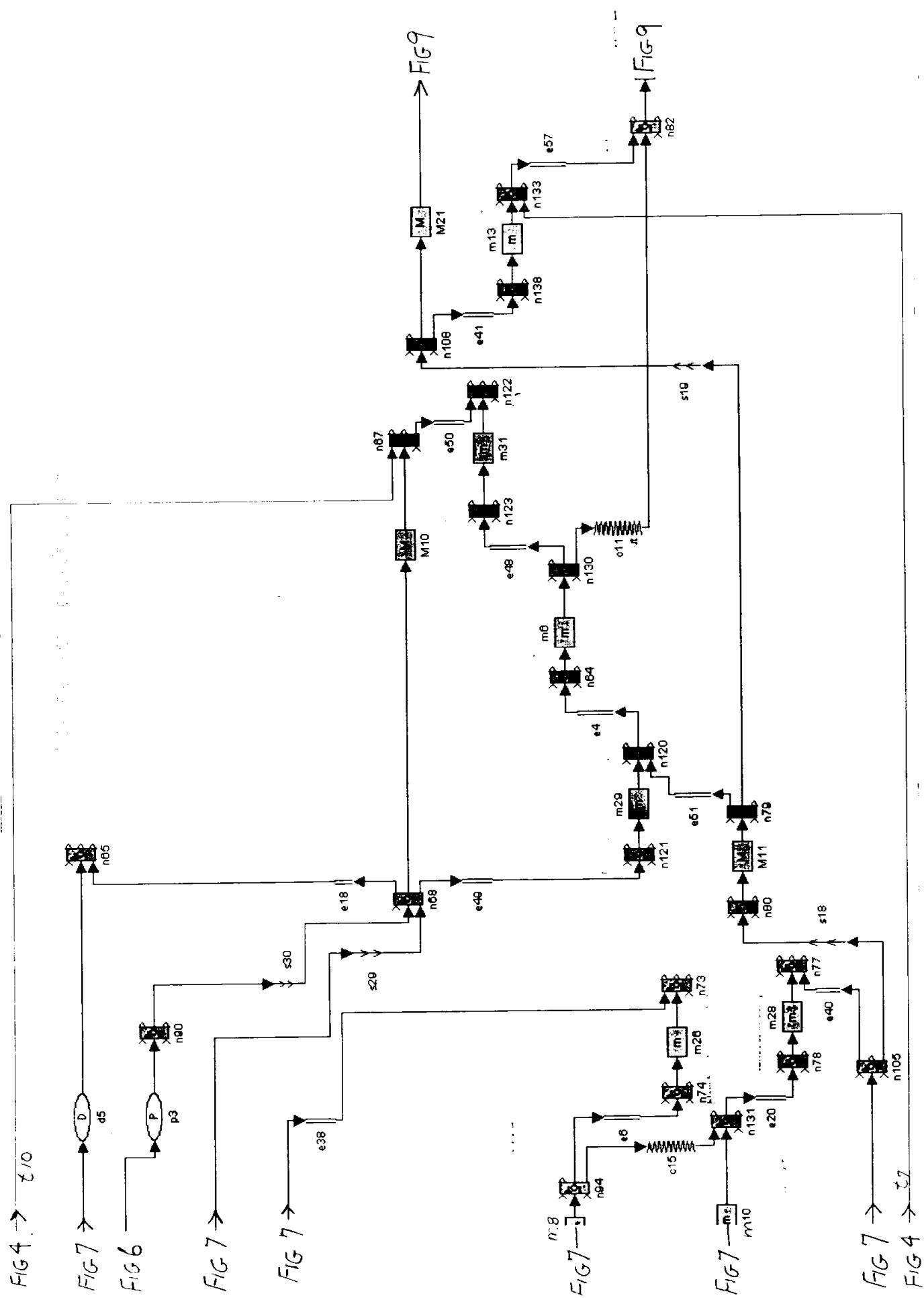
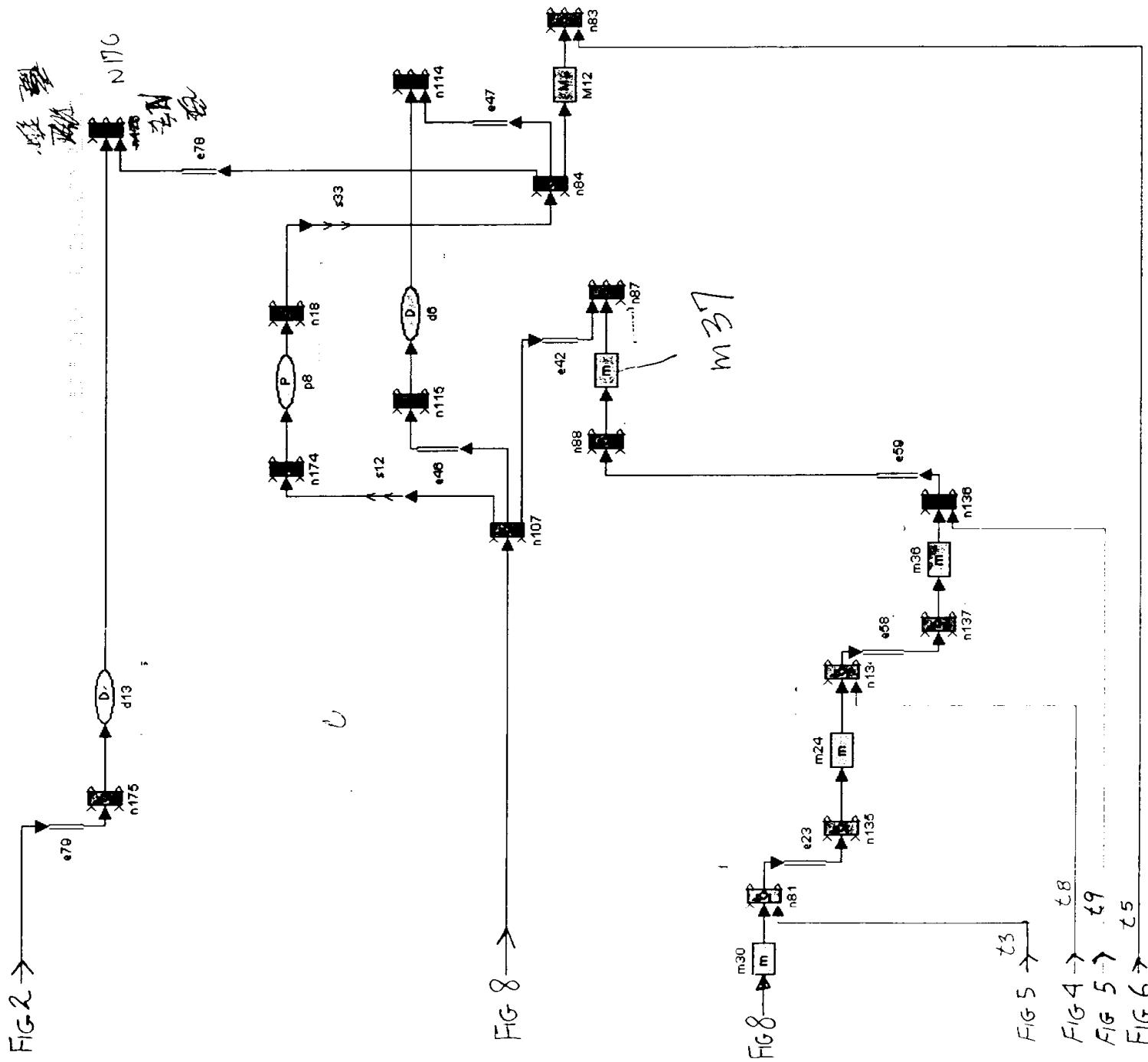


Fig 9



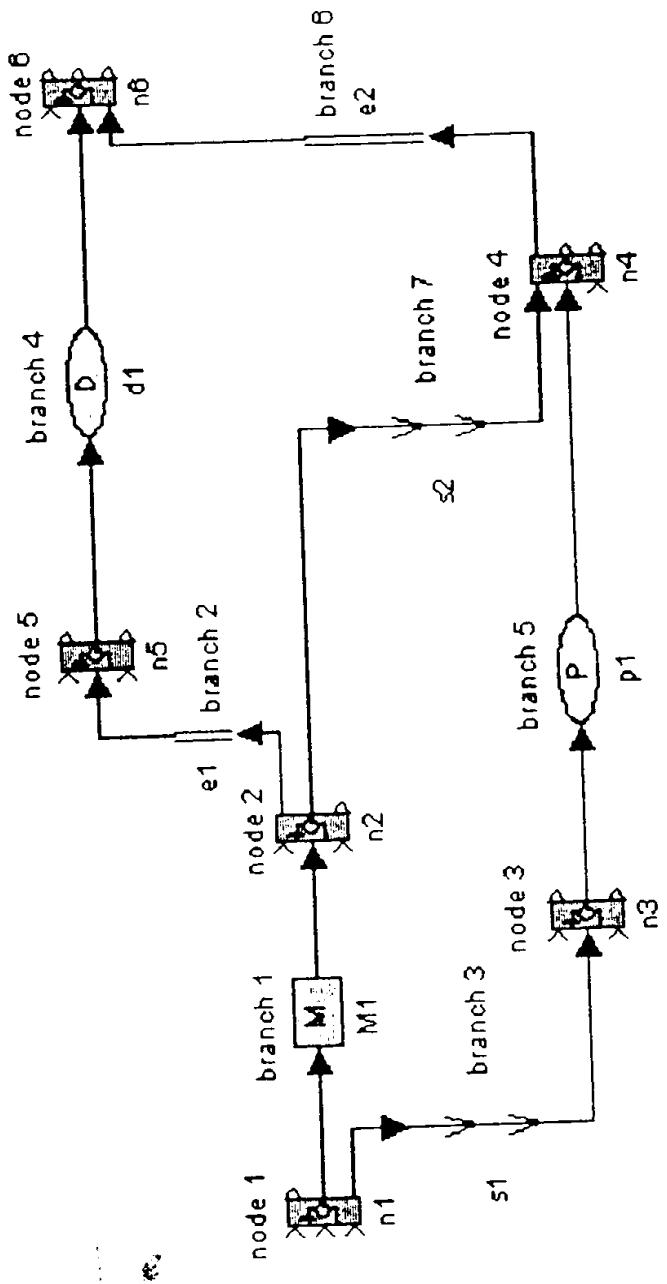
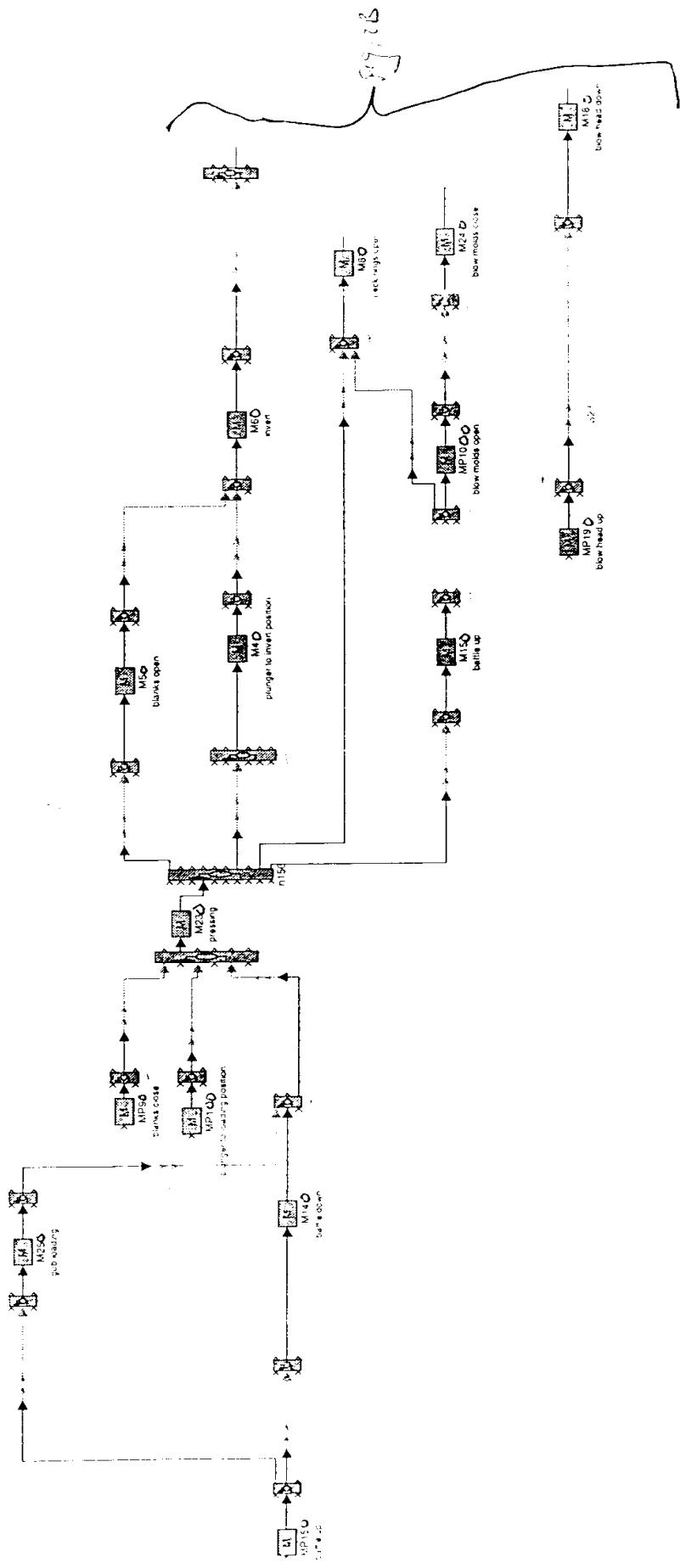


Fig - 10

		G	H
	Events	ON	OFF
1			
2	Gob Interceptor	334	14
3	Blanks Close	324	130
4	Blanks Open	130	321
5	Plunger Up	33	123
6	First Baffle	9	125
7	Plunger Down	127	327
8	Funnel	1	150
9	Settle Blow	1	1
10	Plunger Cooling	150	260
11	Invert	200	260
12	Neckring Open	274.5	283
13	Revert	282	172
14	Molds Close/Open	229	170
15	Mold Cooling	10	150
16	Blowhead	290	113
17	Final Blow	348	120
18	Take Out IN	137	197
19	Tongs Close	178	78
20	Take Out OUT	197	90

Fig - 11

Fig - 12 A



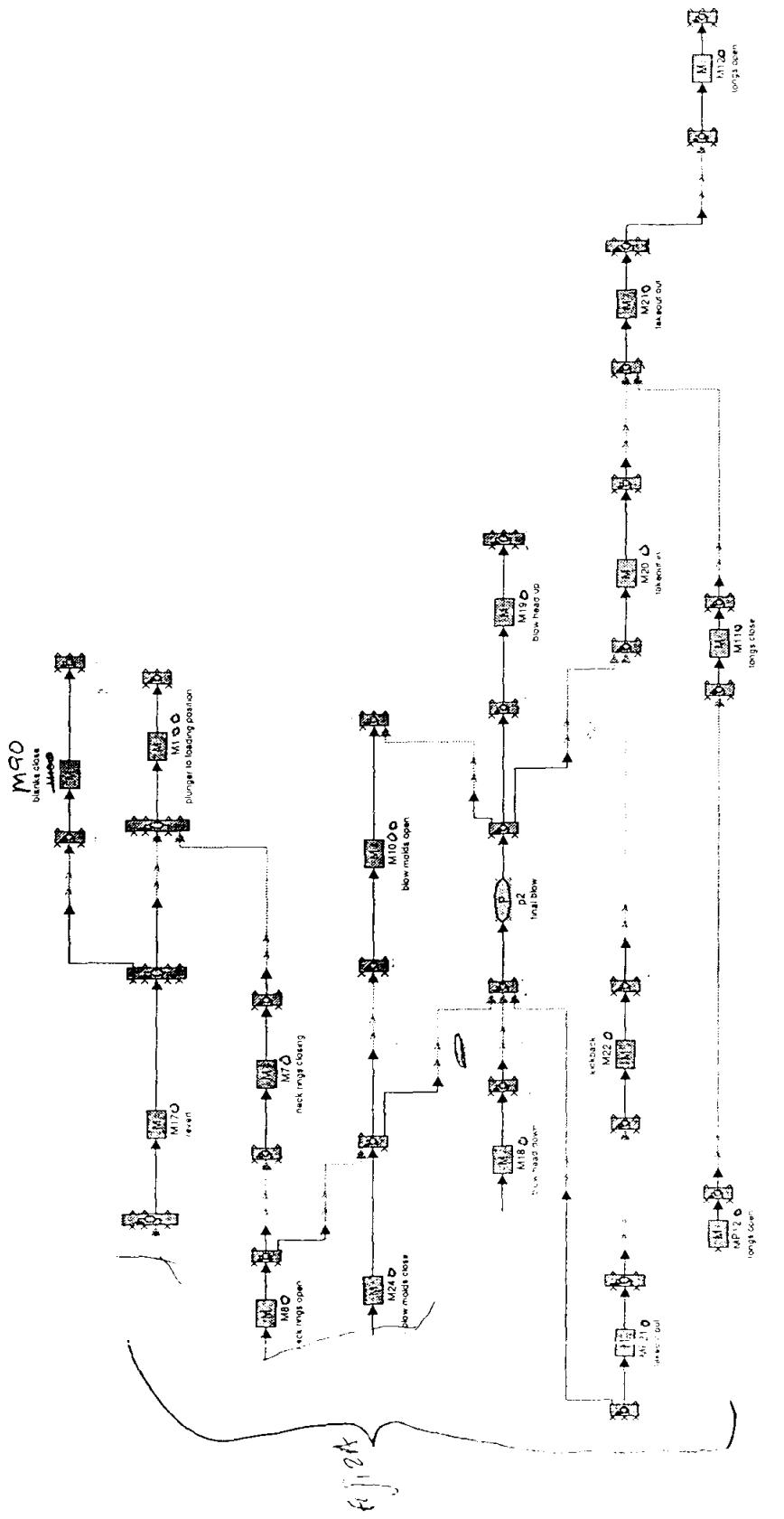


Fig 12B

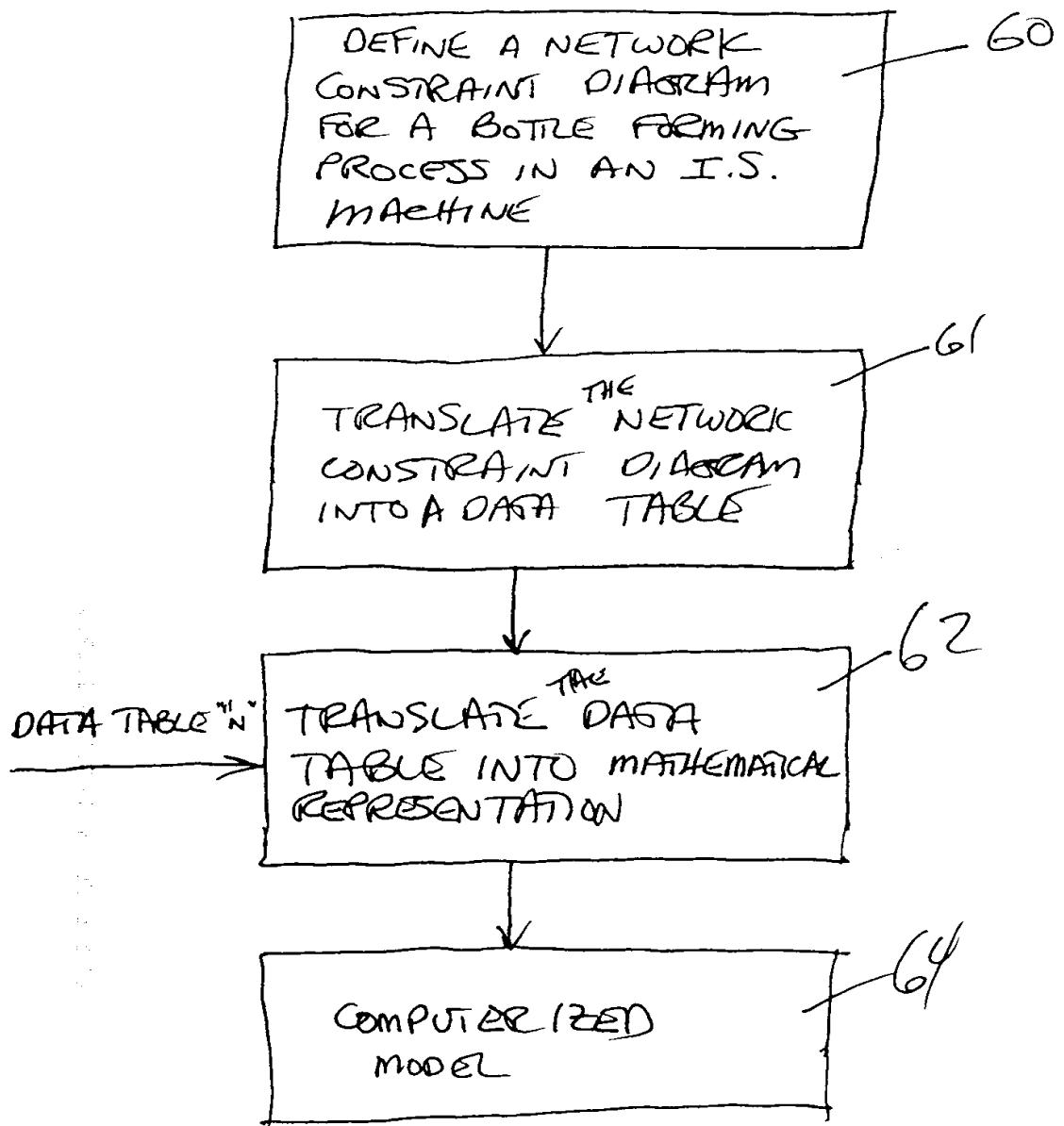


Fig - 13

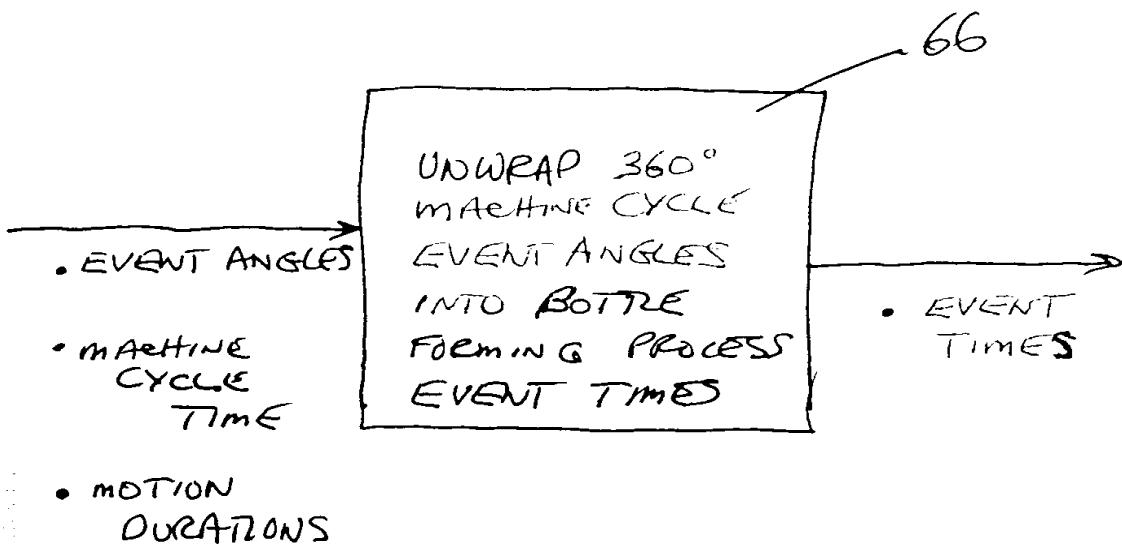
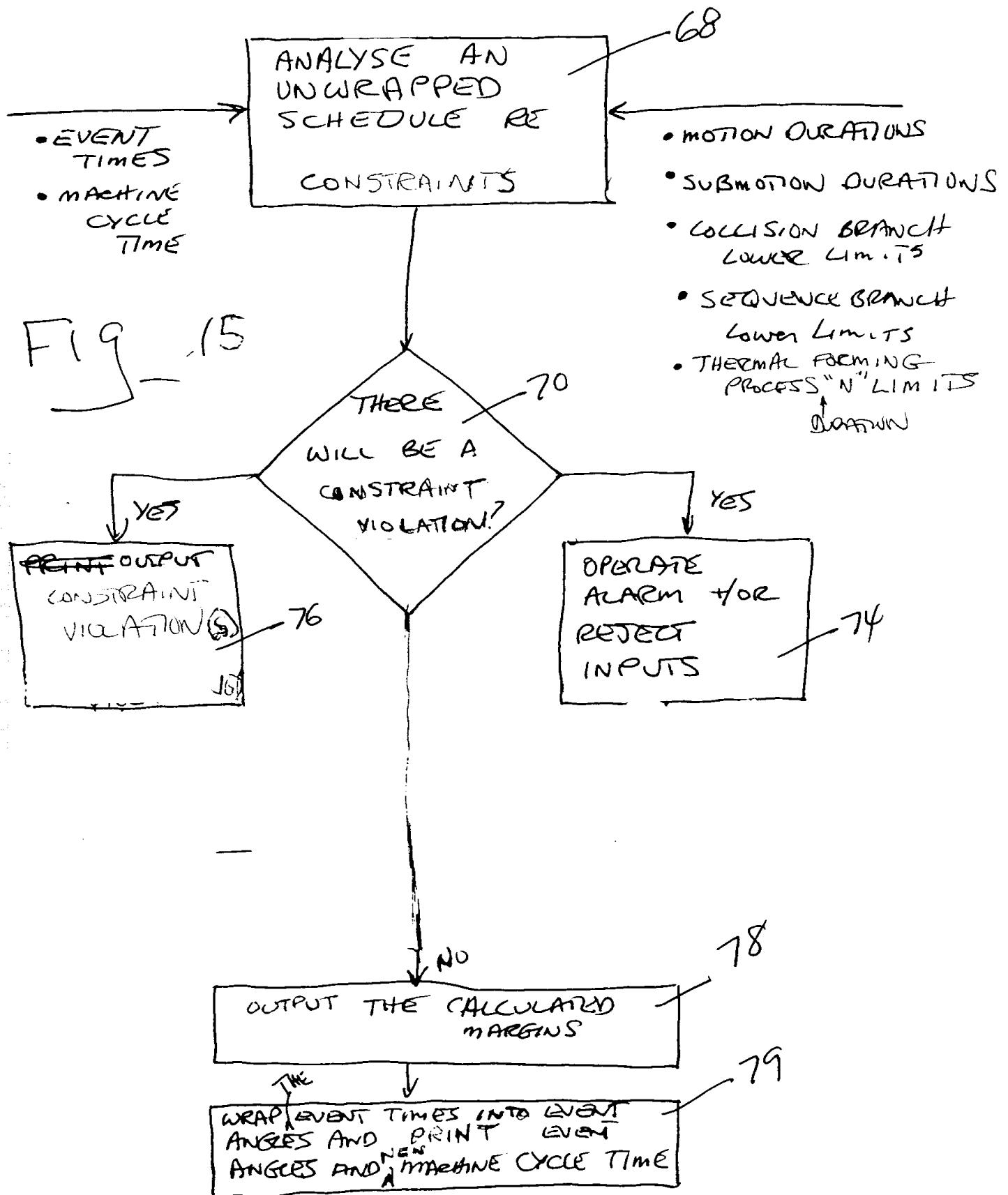
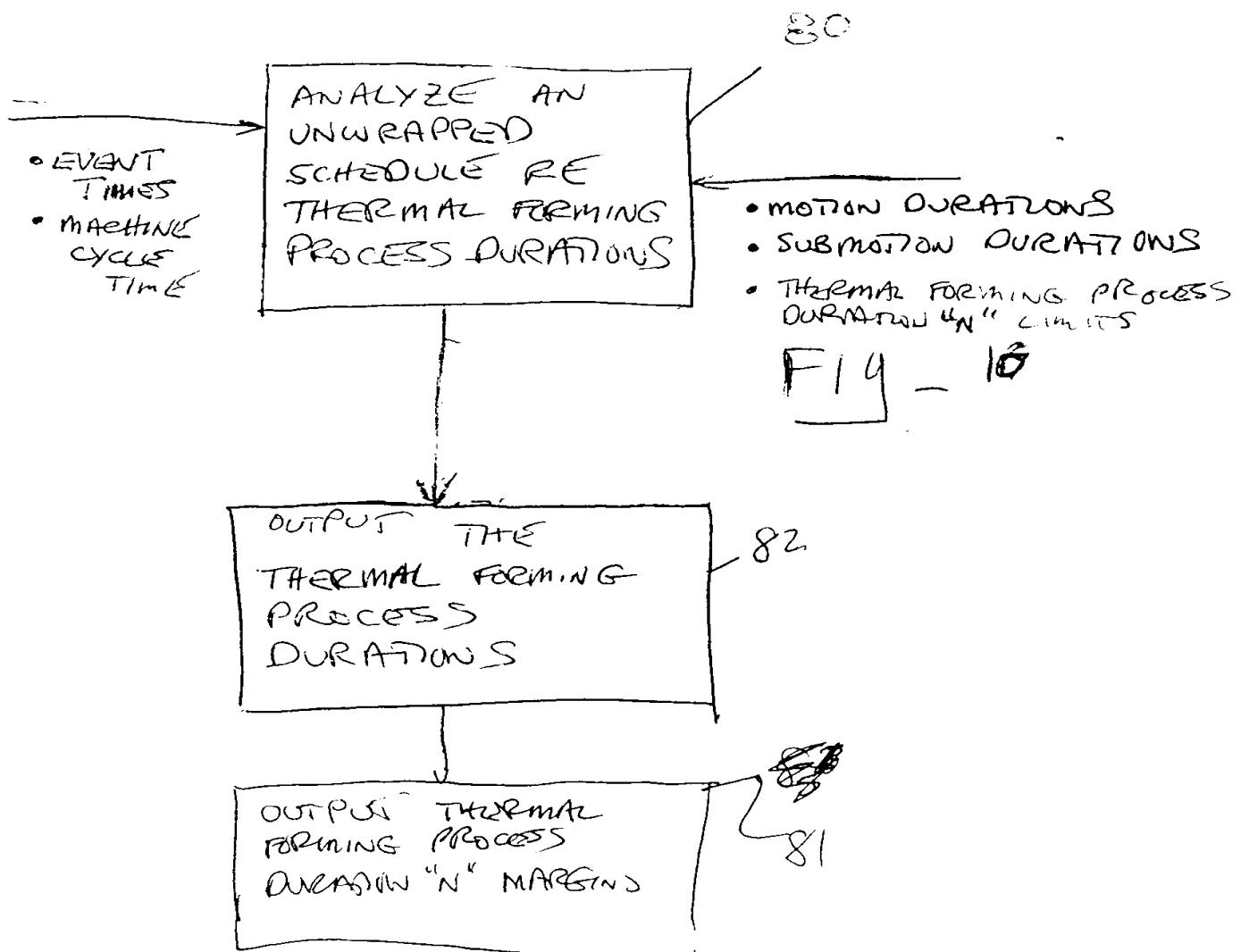
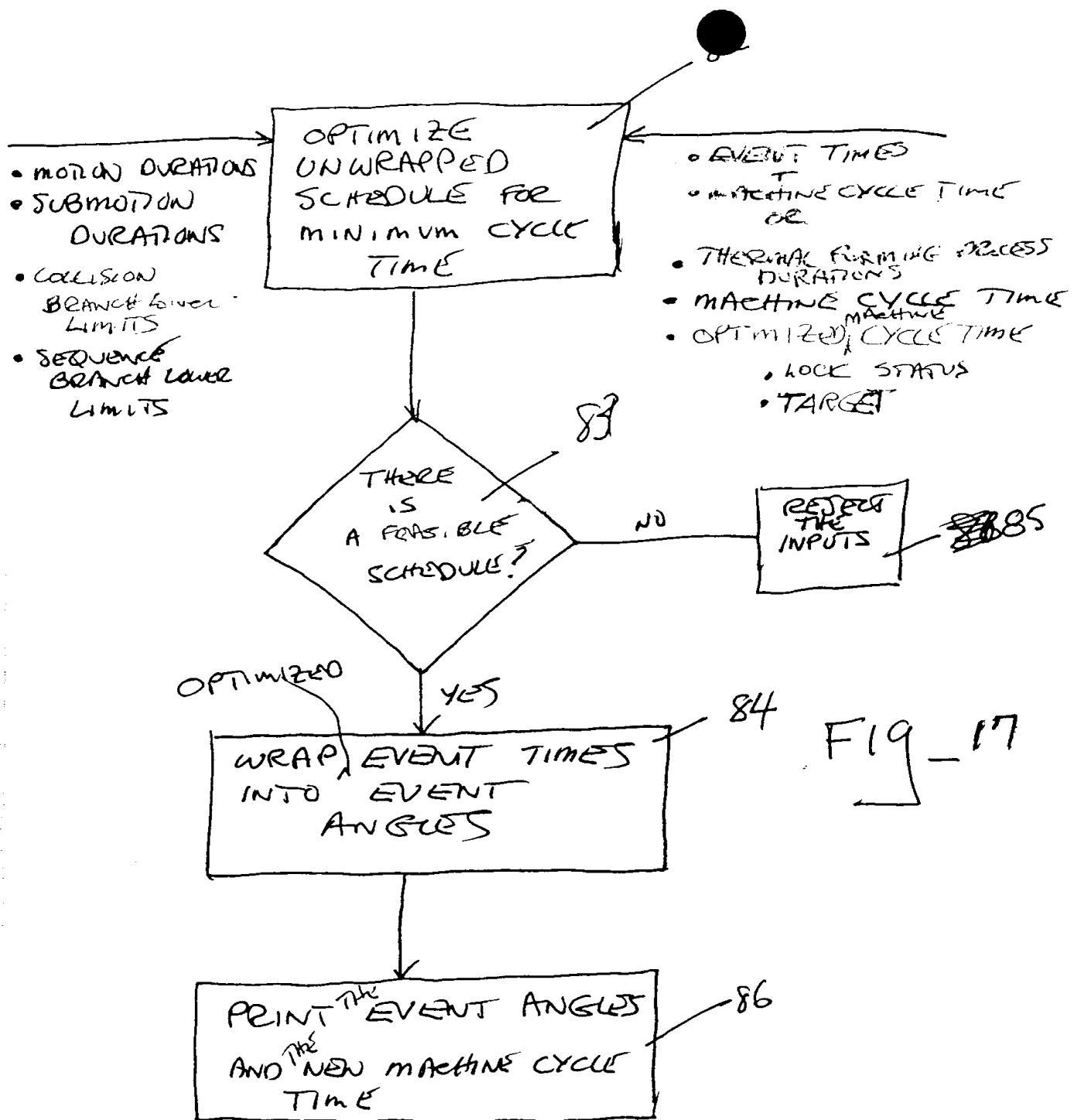
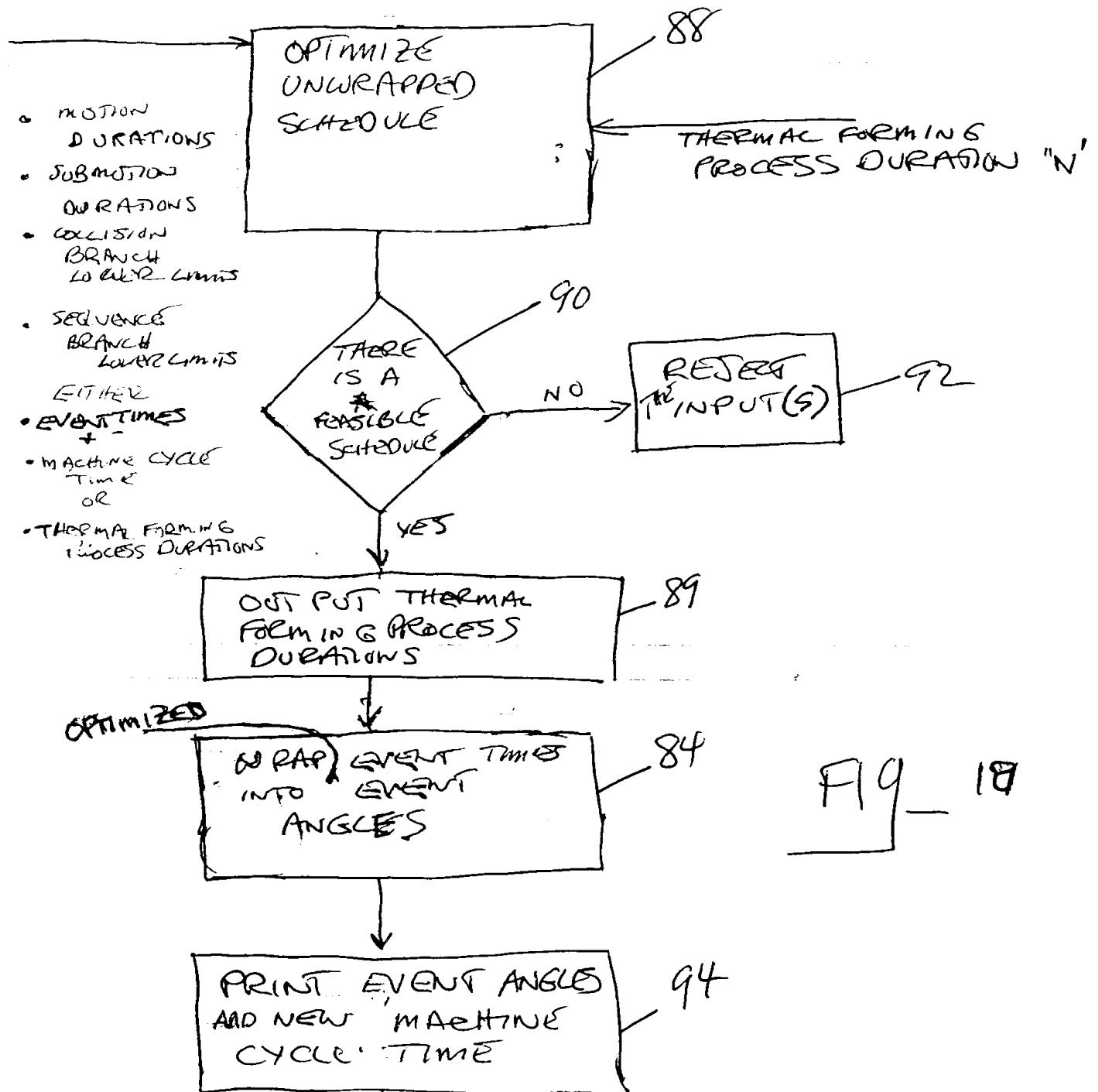


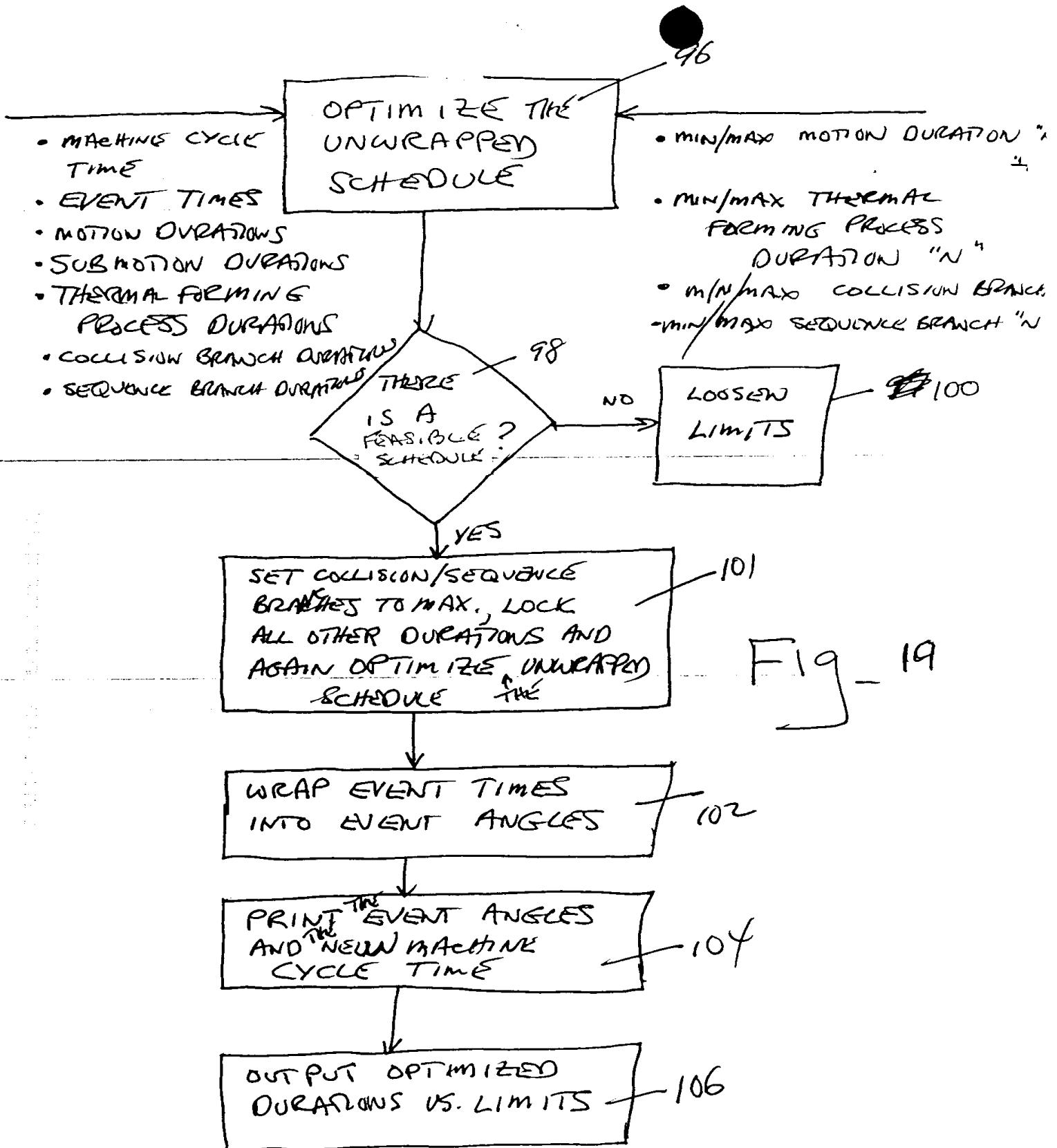
FIG - 14











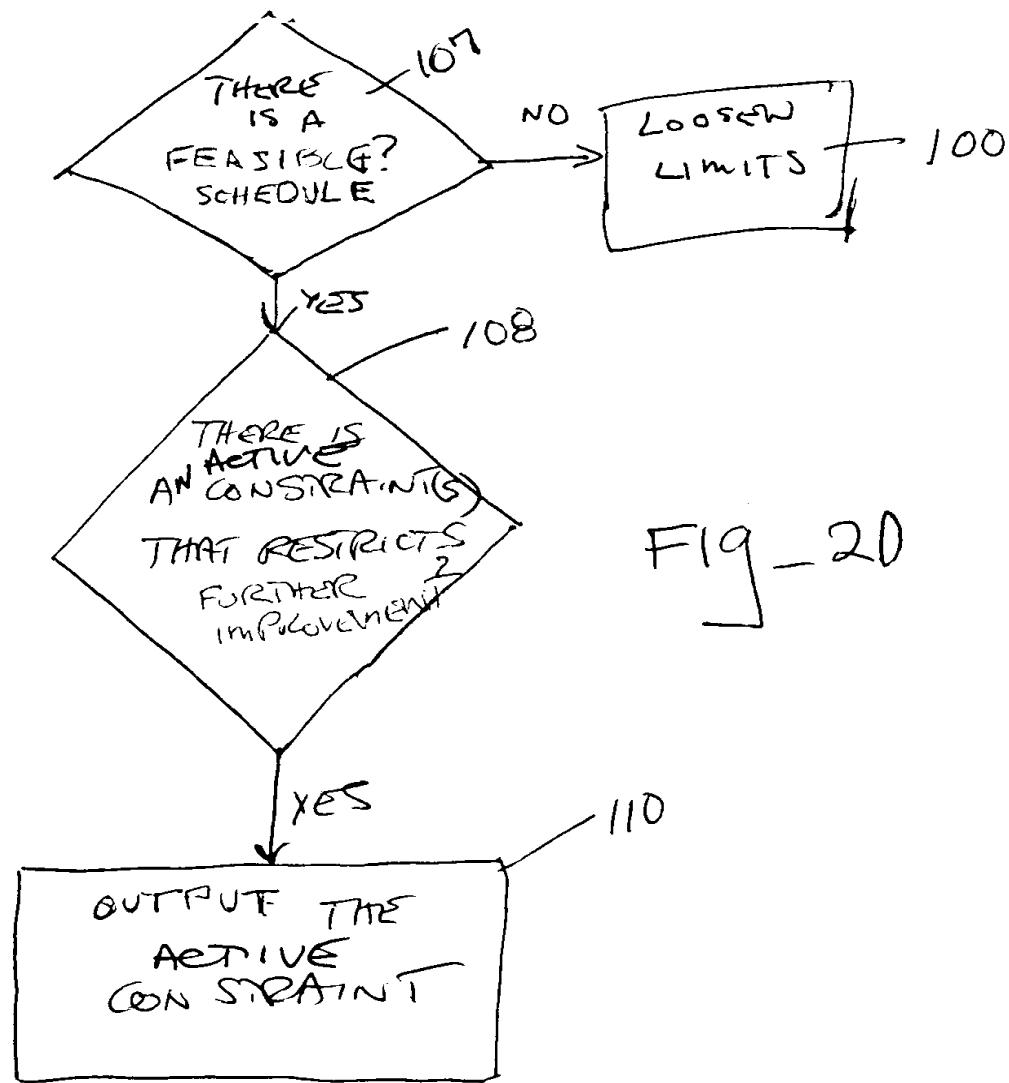


FIG - 20

